Page 1

May-16-13 3:54:51 PM Item ID: D3219-1 Accept *N900040100* Setup Start **Revision ID:** Item Name: Plate Start Date: 5/16/13 **Start Qty: 60.00** *60* **Cust Item ID:** Req'd Qty: 60.00 Required Date: 5/24/13 *60* **Customer:** Reference: Run Process Plan: MLJ Date: 13-05-16 Tooling: Approvals: Date: Stop Date: SPC (Y/N): Date: Sequence ID/ Operation Set Up/ **Tool ID** Tool # Plan Reject Accept Reject Insp. Work Center ID Description **Run Hours** Qty Code Qty Number Stamp Draw Nbr **Revision Nbr** D3219 Rev A 100 0.00 FLOW WATER JET JMB-5.27 *100* Waterjet 0.00 Memo FLOW CNC Waterjet 1-Cut as per Dwg D3219 Dwg Rev: 6061,125 Prog Rev: 110 QC2- Inspect parts off machine FAI/FAIB 0.00 *110* JMB-5-27 QC 0.00 Memo Quality Control 120 QC8- Inspect parts - second check *120* QC 0.00 Memo Quality Control

101870

May-16-13 3:54:51 PM

Item ID:

Revision ID:

D3219-1

Item Name: Plate

Start Date: Required Date: 5/24/13

5/16/13

Req'd Qty: 60.00

Start Qty: 60.00

60 *60*

N900040100

Setup Start

Cust Item ID:

Customer:

Tool ID

Reference:

Approvals:

Process Plan: _____ Date: ____ Tooling:

QC: _____ Date:

Accept

SPC (Y/N):

Date: Date:

Run

Sequence ID/	Operation
Work Center ID	Description
130	
130 Small Fab	Small Fab Memo
Small Fab	1-Deburr if necessary

Set Up/ **Run Hours** 0.00

Tool # Plan Accept Code Qty

Reject Qty

Reject Insp. Number Stamp

140

Quality Control

QC5- Inspect part completeness to step on W/O

Memo

0.00

150

150 Packaging

Packaging

Identify as per dwg & Stock Location: Mt 503 0.00

Memo

*** STOCK IN STEP CELL***

0.00

Page 3 May-16-13 3:54:51 PM Item ID: D3219-1 Accept *N900040100* Setup Start **Revision ID:** Item Name: Plate **Start Date: Start Qty:** 60.00 5/16/13 **Cust Item ID:** Required Date: 5/24/13 Req'd Qty: 60.00 **Customer:** Reference: Run Start Approvals: Process Plan: _____ Date: ____ Tooling: Date: Stop QC: _____ Date: ____ SPC (Y/N): Date: Sequence ID/ Operation Set Up/ Tool ID Tool # Plan Reject Reject Accept Insp. **Work Center ID** Description **Run Hours** Number Stamp Code Qty Qty 160 QC21- Final Inspection - Work Order Release 0.00 *160*

Quality Control

Memo

0.00

Picklist Print

May-16-13 3:54:58 PM

Work Order ID: 101870

Parent Item: D3219-1

Parent Item Name: Plate

101870 *D3219-1*

Start Date: 5/16/13

Required Date: 5/24/13

Start Qty: 60.00 Required Qty: 60.00

Comments:

IPP A04.04.19New issueKJ/JLM

ESR B 06.05.25 Waterjet EG

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	_	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6S.125		Purchased	No			100	sf	187.9862	0.0964	6:088421			
M6061T6 6061-T6 .125 Sheet	S 125								**	6.1.		J	m13-5-27

Location	Loc Qty	Loc Code	
MAT021	187.9861578		
121473	0.9161578		•
123279	72.89		
125257	114.18		F26761

Page I

DART AEROSPACE LTD	Work Order:	10187e
Description: Plate	Part Number:	D3219-1
Inspection Dwg: D3219 Rev: A		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments		
Ø0.316	+0.005/-0.000	0.317"	-		V			
2.293	+/-0.005	2.295"	~		V			
2.965	+/-0.010	2.966"	_		ν			
0.566	+/-0.010	0.566	-		V			
0.375	+/-0.010	0.370"	_		V			
R0.125	+/-0.010	0.125	~		RG			
13.9°	+/-0.5°	13.90	V		#Conp.			
			·		***			
						,		
·								

			_
Measured by: JM	Audited by:	Prototype Approval:	N/A
Date: 13-5-27	Date: 13.5 37	Date:	N/A

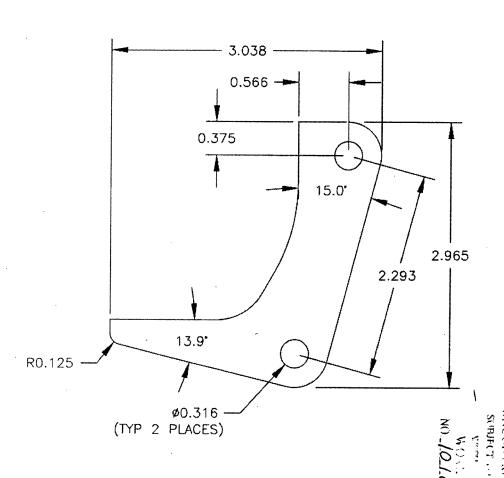
Rev	Date	Change	Revised by	Approved
Α	04.04.19	New Issue	KJ/JLM	<u> </u>
В	07.09.06	13.9° dimension added	KJ/JLM	
С	08.04.15	0.125 dimension removed	KJ/DD 🔏	1/2





DESIGI	W (A)	DRAWN BY		ROSPACE LTD , ONTARIO, CANADA
CHECK	ED,	APPROVED,	DRAWING NO.	REV. A
	#	THE STATE OF THE S	D3219	SHEET 1 OF 1
DATE			TITLE	SCALE
 03.1	0.10		PLATE	1:1
Α		03.10.10	NEW ISSUE	





D3219-1 PLATE

- 1) MACHINE PER DWG FILE "D3219-1.SLDPRT"
- 2) MATERIAL: 6061-T6, 0.125 THICK (QQ-A-250/11)
 - (REF DART SPEC M6061T6S.125)
- 3) FINISH: NONE
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

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